

Work Order ID 71142

Thursday, June 23, 2011 12:34:41 PM



Page 1

Item ID: D3642-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: ymf Date: 1-06-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3642	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024 .050

B11-6-07

(6)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-07

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 6 b7

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6X Ø M-11/06/27

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Ruf/8/28 (6)

150

Identify as per dwg & Stock Location: 277

0.00



Packaging

Memo

0.00

Packaging

Ruf/8/28 (6)

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Page 3

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Item Name: Doubler

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/2011
MS
11-06-23

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:34:37 PM

Page 1

Work Order ID: 71142

Parent Item: D3642-1

Parent Item Name: Doubler



Start Date: 6/23/2011

Required Date: 7/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

116.3000

0.1664

1.050947



HB116-27

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

116.3

117684

116.3

117684

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	71142
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.128	✓		✓ B52	
Ø0.098	+0.004/-0.001	.100	2		✓	
0.35	+/-0.030	.352	8		✓	
1.25	+/-0.030	1.253	2		✓	
1.700	+/-0.010	1.701	2		✓	
2.15	+/-0.030	2.151	2		✓	
3.05	+/-0.030	3.052	2		✓	
3.95	+/-0.030	3.951	2		✓	
4.078	+/-0.010	4.078	2		✓	
4.85	+/-0.030	4.851	2		✓	
5.20	+/-0.030	5.209	X		✓	
0.343	+/-0.010	.342	2		✓	
0.40	+/-0.030	.398	2		✓	
1.30	+/-0.030	1.323	2		✓	
3.35	+/-0.030	3.347	1		✓	
3.47	+/-0.030	3.461	1		✓	
3.79	+/-0.030	3.79	2		✓	
3.959	+/-0.010	3.957	2		✓	
4.08	+/-0.030	4.084	2		✓	
4.60	+/-0.030	4.609	2		✓	
1.537	+/-0.010	1.537	2		✓	
3.28	+/-0.030	3.284	2		✓	
3.80	+/-0.030	3.80	2		✓	
3.915	+/-0.010	3.918	2		✓	
0.450	+/-0.010	.449	2		✓	
4.066	+/-0.010	4.066	2		✓	
4.20	+/-0.030	4.197	2		✓	

Measured by: B	Audited by: D	Prototype Approval:	N/A
Date: 11-6-07	Date: 11/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

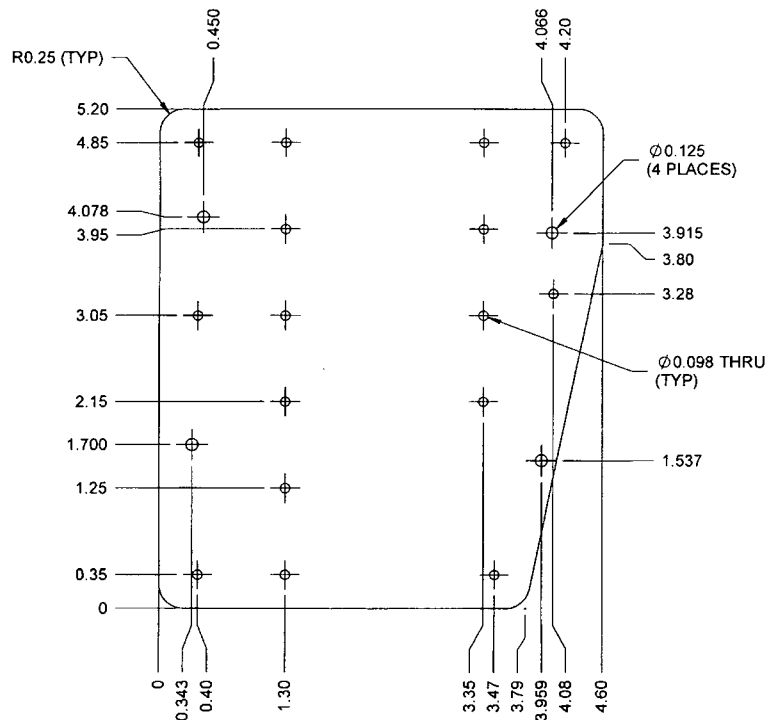
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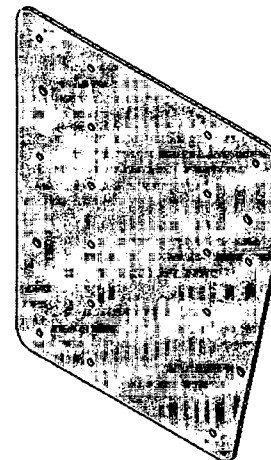
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D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)



#71142

RELEASED
07.11.14

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	UK		
CHECKED	AK	DRAWING NO.	REV. B
MFG. APPR.	EG	D3642	SHEET 1 OF 1
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	DOUBLER	4:5
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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